Work Order Monday, March 1				*1	149	4.3	*							Page 1
Item ID:	03640-3			Accept	*	/JQ	ററ	040	100)*	Setup		. 1 7	S1*
Item Name: B	Belt Guide				3							Stop	*N	S2*
Start Date: 3	/17/14	Start Qty: 12.00	*12*			Cust	Item II	D:						
Required Date: 3	/17/14	Req'd Qty: 12.00	*12*			Cust	omer:							
Reference:														
Approvals:	Process Pla	in: MLJ	Date: 4-03-18	Tooling:			Da	te:			Run	Start	"17	R1*
(QC:		Date:	SPC (Y/N):			Da	te:	<u></u>			Stop	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hou	rs	То	ol ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr												
D3640	Rev	A												
100				0.00							- 10-11			luk
100		BAND SAW				į				_/2		Ø		/14/03/
Bandsaw Jeaspa Bandsaw		Memo	3.8 " long	0.00								•		
Jeaspa Banusaw		Cut blank	5.8 long											
•		7.												
110				0.00										
110		HAAS CNC VERTICA	AL MACHINING #1		DAS 44	14/	3/20	_		12-	\mathcal{C}	Y		
HAAS 1		Memo		0.00	9-89	. , ,	13/2	•		1	 X			
HAAS CNC vertical n	nachine #1		per Folio FA670 & Dwg D36 ection with deburring tool.	540 Rev: <u>A</u> 2	-Deburr and	Blend		N.						
120		QC2- Inspect parts off	machine FAI/FAIB	0.00	DAS		ı							
120					4.4	u //	12/-	c		13	1	1		
QC		Memo		0.00	9-89	116	3/2	. \			- +		-	
Quality Control											/			

DQA:		:	Date:											
016			Data			WORK ORDER NON-	-CC	ONFO	RMANCE / UF				_	AEROSPACE
QA Closed:			Date:				-			w	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS		
	-					Rework			Skid-tube	Crosstube	Water Jet			Engineering
Part N	lo.					Scrap		ь н		Small Fab			\exists	Quality
	•				_	Use-as-is		Thern	noforming	Finishing	1	e/Packaging	ヿ	Other
NCR 1	۱o.					Suspected Unapproved			Large Fab	Composite]	Supplier		
												. <u>-</u>		
Root		:			Desc	ription of work order update	-	Initial	Acti	on	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	1	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre	\Box													
Material	\Box			٠.										
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport					ļ									
Unapproved			<u> </u>				<u> </u>				<u>.</u>			
						······································	FA	ULT CA	TEGORY					
Landi		1			_	General		1		_	1	. г	_	<u>.</u> .
i		Bending			-	Bend		┥ :	rogram	_	Outside Dim	+		Pressure/Forced
		Centre No	ot Concer	itric	-	BOM/Route	<u> </u>	Grain			Over/Under			Set-up
	H	Cracks	-1./D:1-	// / /	-	Broken/Damage/Defect	_	Hardwa			Part Incorred	- F		Temperature/Cure
	 	Crimp/Kir	тк/кірріе,	/wave	ļ	Burrs	_	1 .	ion Incomplete/Un	· -	Part Lost/Mi	ssing	-	Weld
i	-	Crushing			\vdash	Countarink	<u> </u>	4	ions Incomplete/U	nciear	Part Moved	\/		Wrong Stock Pulled
	-	Crushing	.+		-	Countersink	\vdash		gned/off center	<u> </u>	Positioned W	· ·		Other
		Heat Trea		Tuba	<u> </u>	Cut Too Short	_	Mislabe			Power Loss/	Surge [Other
	\vdash	Marks/Ch	•	eauı	<u> </u>	Drawing Drill Holes	<u> </u>	Misrea						
	\vdash	ì			-	Finish	\vdash	Off-set						
	Turning Sequence			\vdash	Fit/Function	-	-	Calibration						
	Wave/Twist in Tube			/ C		programenon	ı	Jour of :	Sequence					

Work Orde				*114943*								Page 2		
Item ID: Revision ID:	D3640-3			Accept	*N(ററ	040	100)*	Setup	Start Stop	· I \	S1*	
Item Name: Start Date: Required Date: Reference:	Belt Guide 3/17/14 3/17/14	Start Qty: 12.00 Req'd Qty: 12.00	*1 <i>2</i> * *1 <i>2</i> *			st Item I stomer:	D:				зюр	*N.	S2*	
Approvals:		n:	Date:	Tooling: _ SPC (Y/N):			nte:			Run	Start Stop	^IV	R1* R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	To	ool ID	Tool#	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp	
*130 *130* QC Quality Control		QC8- Inspect parts - seco	nd check	0.00					12	(Ø_		DAS 40 9-89- 14/03/2	
*140 *140* Packaging Packaging		Identify as per dwg & Sto	ck Location:	0.00					_{/9	-/3 <i>/</i>	/3)	_(13	DAS 32 9-89	
150 *150* QC		QC21- Final Inspection -	Work Order Release	0.00							1/14-	03-3,	/	

Memo

Quality Control

DQA:			. Date:			. WORK ORDER MON	DART							
QA Closed:			Date:			WORK ORDER NON-	-C(JNFOI	RMANCE / UI		Work Order uj	odate only	7	AEROSPACE
Mork Orde						DISPOSITION					DEPARTMENT			
Work Orde	er: .					Rework]		Skid-tube	Crosstube	7	Water Jet	\neg	Engineering
Part N	۷o. ِ					Scrap		1					Quality	
NCR I	No.					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite				Other
Root					Desc	ription of work order update		nitial	Acti	ion	Sign &		T	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	1	QC Inspector
Design														
Doc/Data	Щ													
Equip/Tooling	Ш												ŀ	
Handling/Pre	Ш												Ì	
Material														
Operator											ļ			
Offset/Setup				ļ										
Process														
Supplier														
Training													Ì	
Transport									•					
Unapproved														
							FA	ULT CA	TEGORY					
Landi	ng (Gear				General		/					•	
		Bending				Bend		Folio/F	Program	Γ	Outside Dim	ensions	\Box	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ci	7	Temperature/Cure
		Crimp/Kiı	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	nqualified	Part Lost/M	issing	╗	Weld
		Cuffs				Contamination		Instruct	tions Incomplete/U	Inclear	Part Moved		٦	Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center		Positioned V	ے Vrong		•
Heat Treat Cut Too Short			Cut Too Short		Mislabe	=	ļ	Power Loss/		\Box	Other			
			Drawing		Misrea	d	_							
		Marks/Cl				Drill Holes	Off-set							
		Turning S				Finish	Out of Calibration							
		• —				Fit/Function		4	Sequence		•			***************************************

Picklist Print

Monday, March 17, 2014 2:32:36 PM

Work Order ID: 114943

114943

Parent Item:

D3640-3

D3640-3

Parent Item Name: Belt Guide

Start Date: 3/17/14

Required Date: 3/17/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A New Issue 07-01-15 JLM

Component	Item	ID
Item Name		

Replacement Mfg/ Item ID

Purch

Primary Bin Item Location Last Location

Route Seq ID Unit of Measure

Qty on Hand

Qty per Kit Total

**

Qty

Date Status Issued

Purchased

No

100

0.0040

Page 1

MDELRINBO.75X1.250

0.4

5.052631

Issued

Qty

MDFI RINB0 75X1 250 Delrin Bar

Location

MAT039

Loc Qty

Loc Code 0.004

m127442

0.004

(this butch only)

M DELRIN B 0,750 X1,000 M128113

not not fulled

DQA:			Date:											
QA Closed:			Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE	w	ork Order up	ndate only	AEROSPACE	
<u></u>						DISPOSITION			۸۵۸۱		PARTMENT	·		
Work Orde	er:					DISPOSITION			— AGAI	M31 DI	.PARTIVICIVI)	/PROCE33		
Part N	lo					Rework Scrap			Skid-tube Crosst Machining Small	Fab	4	Water Jet d. Eng. Coor.	Engineering Quality	
NCR N	1o. <u> </u>				_	Use-as-is Suspected Unapproved		Thermoforming Finishing Rec/Store/Package Large Fab Composite Supp			re/Packaging Supplier	Other		
Root			•		Descr	ription of work order update		Initial	Action		Sign &	****		
Cause		Date _:	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector	
Design												-		
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material							İ							
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Offset/Setup														
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	Ве	ending				Bend		Folio/F	rogram		Outside Dim	ensions	Pressure/Forced	
	Ce	entre No	t Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
	Cr	acks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	cí 🗌	Temperature/Cure	
	Cr	imp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld	
	Cı	ıffs				Contamination		Instruct	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
,	Cr	ushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	_	
	Не	eat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
	In	spection	Strip in	Tube		Drawing		Misrea	t					
			Drill Holes		Off-set									
	Turning Sequence Finish			Finish		Out of	Calibration							
	Wave/Twist in Tube				Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order:	114943
Description: Belt Guide	Part Number:	D3640-3
Inspection Dwg: D3640 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.58	+/-0.030	3, 575	/		FK-ou	Vern
0.80	+/-0.030	796	7		ø	1
0.13	+/-0.030	85).	7		,	7
0.31	+/-0.030	031	7		8	3
0.200	+/-0.010	.198	7		1	٨
0.40	+/-0.030	,386	7		•	4
0.03 x 45°	+/-0.030 x 0.5°	,03x 45°			0.	Ŋ
0.23	+/-0.030	.22	<u></u>		<i>t</i> /	\
0.40	+/-0.030	.40	7			N
0.625	+/-0.010	,627	7		4	1/
R0.13	+/-0.030	.13	7		R-G	
						· · · · · · · · · · · · · · · · · · ·
		-				

			D40		
Measured by:	FK	Audited by:	40	Prototype Approval:	N/A
Date:	14/03/29	Date:	14/03/29	Date:	N/A
	•		• • •		

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	X

	ार विकास के तर के लेकिन के प्रमुख्याल क अक रणाया जाता है।			•	
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